

D

1. (Currently Amended) Process for producing a laminate (16), comprising at least one polymer film with information and at least one substrate, for further processing for forgery-proof documents,

in which a film (24), comprises at least one polymer film (17) with supporting films (23) arranged at least on both sides, is fed to a first processing station (31), and, in the first processing station (31), at least one supporting film (23) is delaminated on a first side of the polymer film (17), after which at least one substrate (18) is laminated on by an adhesive and subsequently exposed to a crosslinking-active UV radiation and

in which a laminate (44) comprising at least one polymer film (17), at least one supporting film (23) on one side, and at least one substrate (18) on the other side of the polymer film (17) led out from the first processing station (31) is fed to a second processing station (51), and at least one supporting film (23) on the other side of the at least one polymer film (17) is delaminated ~~on a second side of the~~ laminate (44), ~~after which~~ and at least one substrate (19) is laminated on the other side to the at least one polymer film (17) by an adhesive and subsequently exposed to a crosslinking-active UV radiation.

2. (Canceled)

3. (Currently amended) Process according to Claim 1 ~~or 2~~, characterized in that the laminate (16) is led out from the second processing station (51, 51') and wound up on a supply roll (66) or is fed to a downstream processing station.

4. (Currently amended) Process according to ~~one of the preceding~~ Claim//s// 1, characterized in that a film (24), comprising a polymer film (17) with information

1
D

and supporting films (23) arranged on both sides, is drawn off from at least one supply roll (22) or from a prior processing device and is fed to a first processing station (31, 31').

5. (Original) Processing according to Claim 1, characterized in that the first and second processing stations (31, 51) have a roller (38, 58), on the circumference of which there are positioned in each case at least one delaminating device (32, 52), at least one laminating device (34, 54) and at least one curing device (41, 61).
6. (Original) Processing according to Claim 5, characterized in that the roller (38, 58) of the first and second processing stations (31, 51) is wrapped around by the laminate (44) and the laminate (16) by at least 180°, preferably 270°.
7. (Currently amended) Process according to Claim 1, characterized in that the adhesive between the first substrate (18) and the polymer film (17) is cured by the a curing device (41) at least before reaching the second processing station (51).
8. (Currently amended) Process according to ~~one of the preceding claims~~ Claim [[7]] 7, characterized in that a polyethylene film is used as the substrate (18, 19).
9. (Currently amended) Process according to ~~one of the preceding claims~~ Claim [[7]] 1, characterized in that the substrate (18, 19) is subjected to a corona treatment.
10. (Currently amended) Process according to ~~one of the preceding claims~~ Claim [[7]] 1, characterized in that a photo-polymer film, which is at least partially exposed and ~~preferably~~ provide with holograms, is used as the polymer film (17).
11. (Currently amended) Process according to ~~one of the preceding claims~~ Claim [[7]] 1, characterized in that a first and a second supply roll (22, 22') is used and

d
arranged downstream of the supply rolls (22, 22') is a splicing device (27), by which, after one supply roll (22//;// , 22') has been used up, the film (24) of the further supply roll (22, 22') is joined with a butt joint for the continuous processing

12. (Currently amended) Process according to ~~one of the preceding claims~~ Claim [[7]] 1, characterized in that a storage device (28), from which film is taken while the supply rolls (22, 22') are being changed over, is provided between the supply roll (22, 22') and the first processing station (31).

13. (Currently amended) Apparatus for producing a laminate (16), comprising at least one polymer film (17) with information and at least one substrate, for further processing for forgery-proof documents, ~~in particular~~ for carrying out the process according to ~~one of Claims~~ Claim 1 to 12, characterized in that a film (24), comprising at least one polymer film and supporting films (23) arranged at least on both sides, ~~can be~~ is fed to a first processing station (31), in that the first processing station (31) has at least one delaminating device (32) for a first supporting film (23) of the film (24), at least one laminating device (34) for at least a first substrate (18) and at least one curing device (41), and in that a laminate (44) formed by the first processing station (31) ~~can be~~ is fed to at least a second processing station (52), for the ~~further~~ first supporting film (23), at least one laminating device (34) for at least a second substrate (19) and at least one curing device (61).

14. (Canceled)

15. (Currently amended) Apparatus according to Claim 13 ~~or 14~~, characterized in that arranged upstream of the first processing station (31,31') is at least one supply roll (22) for delivering the film (24) and arranged downstream of the last processing station is at least one winding-up roll (66) for storing the laminate (16).
16. (Currently amended) Apparatus according to ~~one of Claims 13 to 15~~ Claim 11, characterized in that at least two supply rolls (22, 22') are provided and a splicing device (27) is arranged between the supply rolls (22, 22') and a first processing station (31, 31').
17. (Original) Apparatus according to Claim 16, characterized in that a storage device (28) is arranged downstream of the splicing device (27).
18. (Currently amended) Apparatus according to ~~one of Claims 13 to 17~~ Claim 11, characterized in that at least one web edge control feeds the laminate (16) to a cutting mechanism (71) by means of a guide line created by exposure.
19. (Currently amended) Apparatus according to ~~one of Claims 13 to 18~~ Claim 11, characterized in that, in a cutting mechanism (71), the laminate is cut to a precise web width and the information carriers can be positioned at a defined distance from the edge of the web by means of a guide line.
20. (Currently amended) Apparatus according to ~~one of Claims 13 to 19~~ Claim 11, characterized in that at least two winding-up rolls (66), which can be changed over on the run, are provided for continuous winding up.

21. (Currently amended) Apparatus according to Claim ~~13~~ 11, characterized in that the angle of wrap of a roller (38, 58) of the first and second processing stations (31, 51) is adjustable by the arrangement of guide rollers (42, 62).
22. (Currently amended) Apparatus according to Claim ~~13~~ 11, characterized in that the rollers (38, 58) of the first and second processing stations (31, 51) are driven jointly.
23. (Currently amended) Apparatus according to Claim ~~13~~ 11, characterized in that the roller (38) of the first processing station (31) is driven in pulling operation and the roller (58) of the second processing station (51) is driven in pushing operation.
24. (Currently amended) Apparatus according to Claim ~~13~~ 11, characterized in that the directions of rotation of the rollers (38, 58) of the first and second processing stations (31, 51) are opposing.
-